

WORK ORDER 2012-16

Date opened: 01 May 2012

Project: Quick Release XL Cargo Basket Assembly
Type: Bell 212

Batch Quantity: 1 Complete Basket Assembly (95510-01)

Approval: C-LSH12-101/D
Drawing List: DCL955-2

Fabrication and Assembly Drawing(s)	Description
95510, Rev. 0	Basket Ass'y
95511, Rev. 0	Basket Body Ass'y
95512, Rev. 0	Basket Lid Ass'y
84255, Rev. 1	Handle Installation
84261, Rev. 1	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y
70405, Rev. 3	Lid Step Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	Y <u>ND</u>
Document Control List revision level matches (or exceeds) STC:	Y <u>✓</u>
Drawings revision levels match Document Control List:	Y <u>✓</u>
Purchase order or Work order source is recorded for each part/ass'y:	Y <u>✓</u>
Tests and inspections specifically called out on drawings are complete:	Y <u>N/A</u>
Release tags associated with all fabricated parts are attached:	Y <u>N/A</u>
All mounting hardware and supplies are included:	Y <u>✓</u>

List all non-conformities raised: _____

Welder Signature: _____

Date: _____

CANNOT BE SIGNED - LSTC
Inspector Signature: _____30 MAY 2012
Date: _____

Drawing: **95510** Revision **0**
 Assembly: **95510-01** **Cargo Basket Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	95510-01	Cargo Basket Assembly			
. 1	95511-01	Basket Body Assembly	Below		
. 1	95512-01	Basket Lid Assembly	Below		
. 1	84255-01	Handle Bar Installation	Below		
. 1	36280-01	Brace Assembly	9-2081 Brace	11078	
. 1	MS20001P4	Piano Hinge		11014	
. 1	95527-01	Placard	0.063 Sheet, 6061-T6 Aluminum	11102	
. 4	49205-14	Bumper	Argus Industries Bumper	11010	
. A/R	CR3213-5-02	Cherry Rivet		11090	
. 8	CR3523-5-02	Cherry Rivet		11061	
. 4	CR3213-4-02	Cherry Rivet		11126	
. 4	40088-14	Fitting	Ancra	11121	
. 8	AN960-616	Washer		11077	
. 1	AN3-15A	Bolt		11077	
. 1	AN3-17A	Bolt		11077	
. 4	AN960-10	Washer		11088	
. 2	AN970-3	Washer		11052	
. 2	MS21044N3	Nut		11088	


Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR Rivets		<i>gc</i>
Final Inspection	Drawing 94010 <i>955</i>			<i>gc</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **95511** Revision 0
 Assembly: **95511-01** Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	95501-01	Basket Body Assembly			
. A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11117	
. A/R	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	11117	
. 4	95530-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	11117	
. 1	95523-01	Attachment Hoop			
. . 1	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	11117	
. . 1	--	Tube	4130 Steel, 1.0" x 0.065 Sqr. Tube	11049	
. . 1	95523-05	Stud	1018 Mild Steel, 5/8" Dia.	12056	
. . 1	95523-07	Stud	1018 Mild Steel, 5/8" Dia.	12056	
. 1	95524-01	Attachment Hoop			
. . 1	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	11117	
. . 1	95523-05	Stud	1018 Mild Steel, 5/8" Dia.	12056	
. . 1	95523-07	Stud	1018 Mild Steel, 5/8" Dia.	12056	
. . 1	76423-04	Cap	1018 Mild Steel, 0.035" Sheet	9010	
. 1	84262-01	Handle Bracket Assembly	Below		
. 1	49215-01	Spacer	1018 Steel, 1/2" Rod	12056	
. A/R	3/4-16F	Mesh	Expanded carbon steel	12005	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing ⁹⁵⁵ 94011			
Final Inspection	Drawing ⁹⁵⁵ 94011			

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Drawing: **95512** Revision 0
 Assembly: **95512-01** **Basket Lid Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	95512-01	Basket Lid Assembly			
. A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11117	
. 1	49216-01	Spacer	1018 Steel, 1/2" Rod	12056	
. 1	84262-01	Upper Handle Bracket Assembly	Below		
. 1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
. A/R	3/4-16F	Mesh	Expanded carbon steel	10112	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 94012			
Final Inspection	Drawing 94012			

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Drawing: **84255** **Revision 1**
Assembly: **84255-01** **Handle Installation**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84255-01	Handle Installation			
. 1	84261-01	Handle Bar Assembly	Below		
. 2	84267-01	Bracket	Delrin, 3/4" Sheet	WO2011-20	
. 2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	11041	
. 2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
. 2	AN3-12A	Bolt		11077	
. 4	AN3-11A	Bolt		11052	
. 12	AN960-10	Washer		11088	
. 6	MS21044N3	Nut		11088	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			<i>gc.</i>

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Drawing: 84261 Revision 1
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bar Assembly			
. 1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	11057	
. 2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
. 2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
. 2	MS20615-4M3	Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

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Drawing: **84262** **Revision 1**
Assembly: **84262-01** **Handle Bracket Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bracket Assembly			
. 4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Sqr. tube	11049	
. 4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
. 2	36275-02	Support	304 Stainless, 5/16" Rod	11093	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

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